

Work Order ID 84717

May-22-12 11:56:09 AM

84717

Page 1

Item ID: D4021-9

Revision ID:

Item Name: Bushing

Start Date: 22/05/2012 Start Qty: 64.00

Required Date: 28/05/2012 Req'd Qty: 64.00

Reference:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

64

64

Approvals:

Process Plan: MLT

Date: 12/08/12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4021 | B |

100

0.00

100

Hardinge

Hardinge CNC Lathe Small

Memo

0.00

TURN AS PER FOLIO EA 868 AND DWG D4021

DWG REV: 3

FOLIO REV: 1/11

***MACHINE TO .375" MAX OD ***

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

26 2-5-29 64 4

26 2-5-27 64 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 84717

May-22-12 11:56:09 AM

84717

Page 2

Item ID: D4021-9 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bushing
 Start Date: 22/05/2012 Start Qty: 64.00 ***64*** Cust Item ID:
 Required Date: 28/05/2012 Req'd Qty: 64.00 ***64*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|---------------------|--------------|---------------|---------------|------------------|---|
| 120 *120* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | <i>inf 12/05/30</i> | | <i>64</i> | <i>10</i> | | |
| 130 *130* Packaging Packaging | Identify as per dwg & Stock Location: <i>WA</i> Memo | 0.00 0.00 | | <i>PL 12-05-31</i> | | <i>64</i> | <i>8</i> | | |
| 140 *140* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | <i>12/6/4</i> <i>MF</i> <i>12-06-01</i> |

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

May-22-12 11:56:12 AM

Page 1

Work Order ID: 84717

84717

Parent Item: D4021-9

D4021-9

Parent Item Name: Bushing

Start Date: 22/05/2012

Required Date: 28/05/2012

Start Qty: 64.00

Required Qty: 64.00

Comments: IPP REV:A NEW ISSUE 09-11-23 JLM VERIFIED BY:DD IPP
Rev:B as per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as
per dwg revB DD 10.04.20 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304R0.375

Purchased

No

f

71.5450

5.312

M304R0 375

**

29 12 - 5 - 29

304 ROUND BAR 0.375

Location

Loc Qty

Loc Code

MAT029

71.545

119346

1.564

120204

2.721

121380 ✓

19.26

121728

48

4.533

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

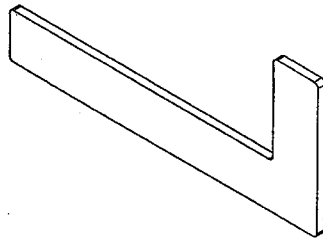
Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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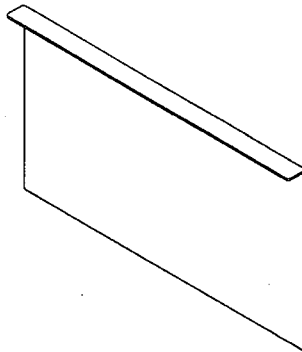
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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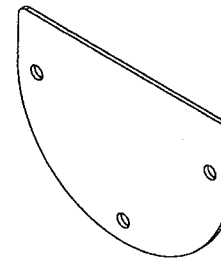
NOTE: Date & initial all entries



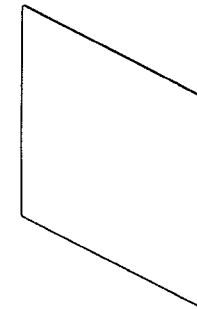
D4021-1 HANDLE PLATE



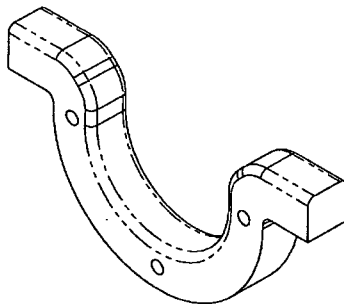
D4021-3 DATA PLATE



D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-7 HOOP



D4021-9 BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84717 MLJ

12/05/22

RELEASED
2010-04-14
MP

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|------------|---|---|----------|
| B | POWDER COAT SPEC ADDED TO NOTE 2 (A8-2) | JPH | 10.04.06 |
| A | NEW ISSUE | JPH | 10.01.29 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4021 REV. B SHEET 1 OF 3 TITLE MISC PARTS - 350 BASKET SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |
| DRAWN | JPH | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.04.06 | | |

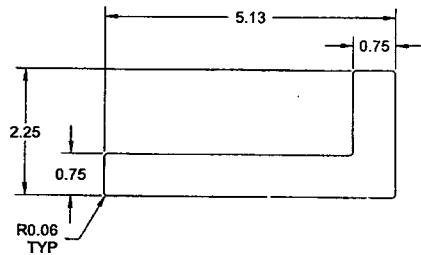
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

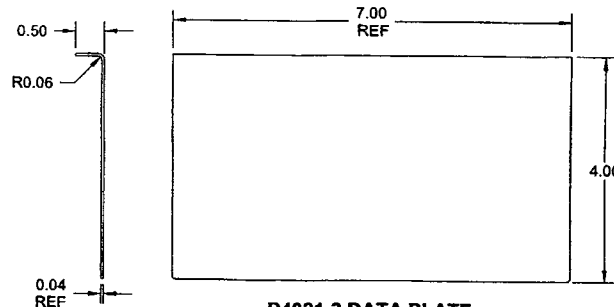
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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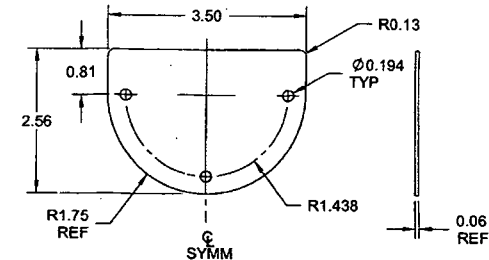
NOTE: Date & initial all entries



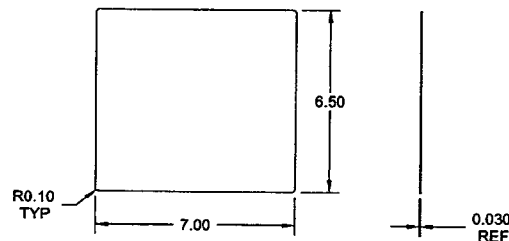
D4021-1 HANDLE PLATE



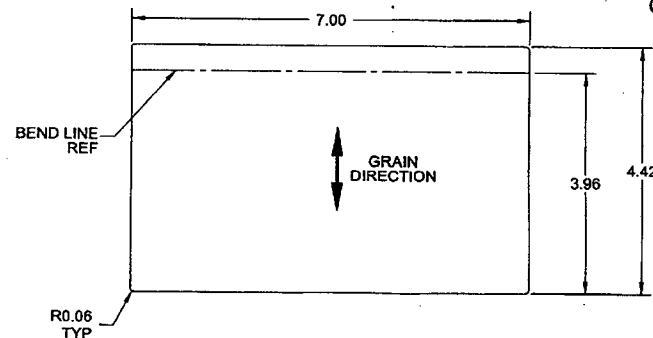
D4021-3 DATA PLATE
MAKE FROM D4021-3F



D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE





D4021-3F DATA PLATE
FLAT PATTERN

NOTES:

- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M303S16GA OR M304S16GA
- 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S22GA

- 2) FINISH: -1/-3/-11: NONE
- 5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.18 lbs
-3: 0.35 lbs
-5: 0.14 lbs
-11: 0.39 lbs

RELEASED
R 2010-04-14
ND

| | | | |
|---|---|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. |  | D4021 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. |  | MISC PARTS - 350 BASKET | NTS |
| DATE | 10.04.06 | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
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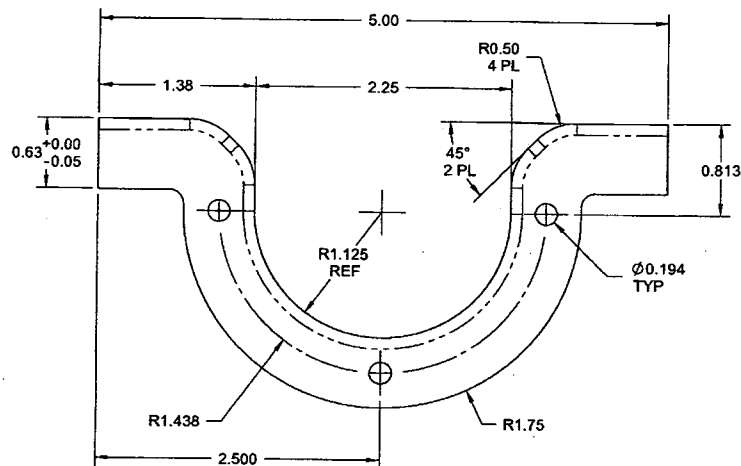
| W/O: | | WORK ORDER CHANGES | | | | | |
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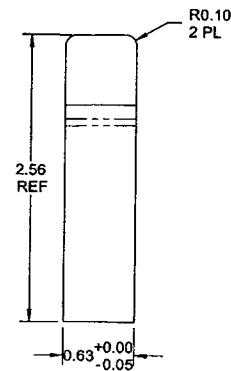
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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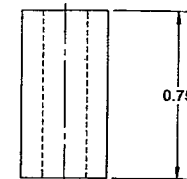
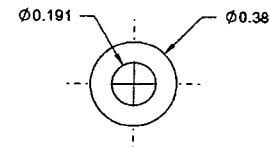
NOTE: Date & initial all entries



D4021-7 HOOP



D4021-9 BUSHING



84717

NOTES:

- 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B
- 9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs

RELEASED
2010-04-14

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|------------|----------|---|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D4021 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | MISC PARTS - 350 BASKET | NTS |
| DATE | 10.04.06 | COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

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